07.04.26

Qty:

Monday, 4/23/2007 1:52:35 PM

User

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

: 31992

Job Number Estimate Number

: 12731

: 30751

P.O. Number This Issue

:NIA

: 4/23/2007

MA

Type

S.O. No. : N/A

: SMALL /MED FAB

Part Number

Material

Due Date

Drawing Name

Drawing Number

 D3535 UNDER Project Number

; N/A **Drawing Revision**

: KB : NIA

: 4/30/2007

: D353535

: WEARPLATE

Each

Written By

Prsht Rev.

First Issue

Previous Run

Checked & Approved By

Comment

New Issue 07-02-15 JLM : Est Rev: A

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

-- 1.0 ----

M304S20GA

304/316 .040 Sheet

Comment: Qty.:

0.8423 sf(s)/Unit

Total: 16.8462 sf(s)

304/316 .040 Sheet (M304S20GA)

Batch: M 101 83

07/04/30

26

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: Prog Rev:

SAD 07/04/30

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

26

26

4.0

QC8

SECOND CHECK



BG

SAD

Comment: SECOND CHECK

NC BRAKE

76

5.0

BRAKE NC

Comment: NC BRAKE

1-Deburr if necessary

2-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326.

3-Identify as D3535-35.

Dart Aerospace Ltd

	WORK ORDER CHANGES							WORK ORDER CHANGES								
STEP	4	PROCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector							
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Part No: _	PAR #:	Fault Category:	NCR: Yes (No)	DQA:	Date: <u>07/05/</u> 0
			OA: N/C C	losed:	Date:

	WORK ORDER NON-CONFORMANCE (NCR)						
	Description of NC		Corrective Action Section B	Varification Approval	Approva		
DATE STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto
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	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Section B Initial Action Description Sign & Verification Section C	STEP Description of NC Section A Section B Initial Action Description Sign & Verification Section C Chief Eng

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:52:35 PM User: Kim Johnston **Process Sheet** Drawing Name: WEARPLATE Customer: CU-DAR001 Dart Helicopters Services Job Number: 31992 Part Number: D353535 Job Number: Seq. #: Description: Machine Or Operation: INSPECT WORK TO CURRENT STEP 6.0 QC5 Comment: INSPECT WORK TO CURRENT STEP POWDER COATING POWDER COATING M101601 Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 8.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock-Location: 10.0 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dar	t Ae	ros	pac	e L	td

W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	:	PAR #: Pault Category: No	CR: Yes	s No DQ	<u> </u> 	Date: _		
			QA:	N/C Close	d:	Date: _		

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC	Description of NC Corrective Action Section B		Verification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approva QC Inspecto
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NOTE: Date & initial all entries

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19.750 2.000 Ø0.188 (TYP 2 PLS) 1.885 -DETAIL A

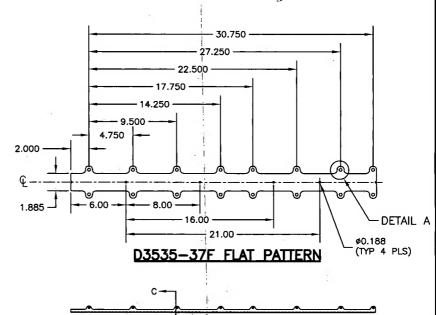
D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL

UNCONTROLLED COPY SUBJECT TO AMENDMENT SHOP COPY WITHOUT NOTICE ENGINEERING RETURN TO

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT &
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

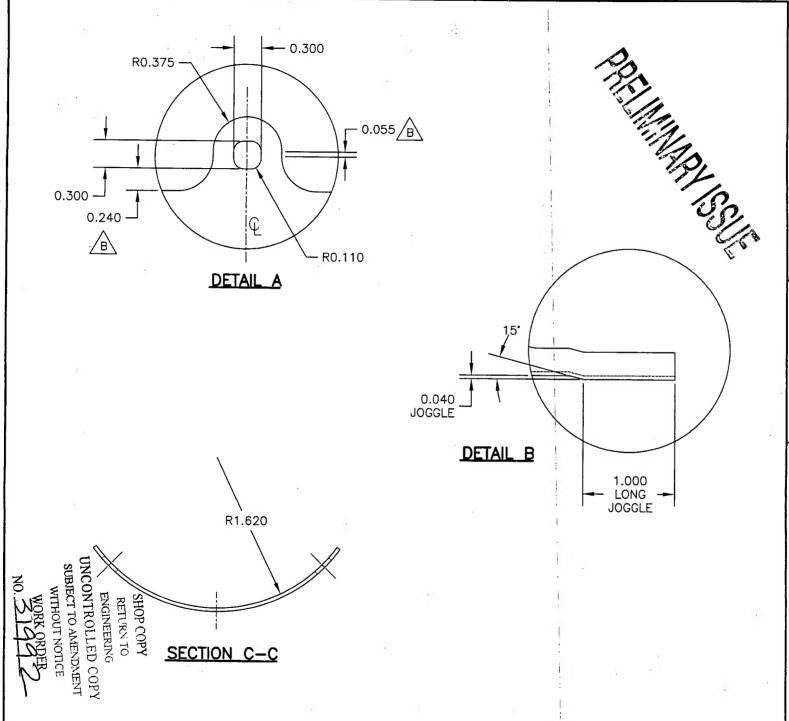


- DETAIL A	
2.000 	27.250 27.250 17.750 4.750 9.500 4.750 DETAIL A PO.188 (TYP 4 PLS) D3535—37 FLAT PATTERN

4		
WEARSHOE 1:10		07.04.17
TITLE SCALE		DATE
D3535 SHEET 5 OF 7		
DRAWING NO. REV. B	APPROVED	CHECKED
DART AEROSPACE USA, INC.	DRAWN BY	DESIGN B

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	CB	# P	DART	DART AEROSPACE USA, INC.
ā	CHECKED	APPROVED	DRAWING NO.	REV.
			D3535	SHEET 7 OF
	DATE		TITLE	SCALE
	07.04.17		WEARSHOE	

DART AEROSPACE LTD	Work Order:	31992
Description: WEAR PLATE	Part Number:	D353535
inspection Dwa: N2635 Rev: 13		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article		Prototype
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	1	Actual	,		Method of	
Inspection Sheet Drawing Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
A 2.000	1/0,010	2,007			Vern	
8 1,885	4-0.00	1.887			Vern	
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0 6.75	+L 0.030	6.754	~		Vern	
EØ0.188	40.005	Ø 6.190	/		Vern	
23.250	4-0.00	23,250			M-T	
6 19. 750	th 0.010	19,750			M-T	
H 17,750	+4-0.010	17.750	W		M-T	
14.250	+1-0.00	14, 250	سن ا		M-T	
9.500	+1-0.010	9.500			Vern	
K 4,750	+1-0.010	4.752	/		yern	nga ngangan manganganana syani mi kumpa ng mang padahan kalaban pangka ng ku ja dang 10 ya dang
2 360	th 0.00	0.296	/		Very	
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Measured by:	SAD	Audited by:	Prototype Ap	proval:	N/A
Date:	07/04/30	Date: 07.05.41		Date:	N/A
Rev Date	Change		F	Revised by	Approved
	New Issue		ŀ	(J/RF	

